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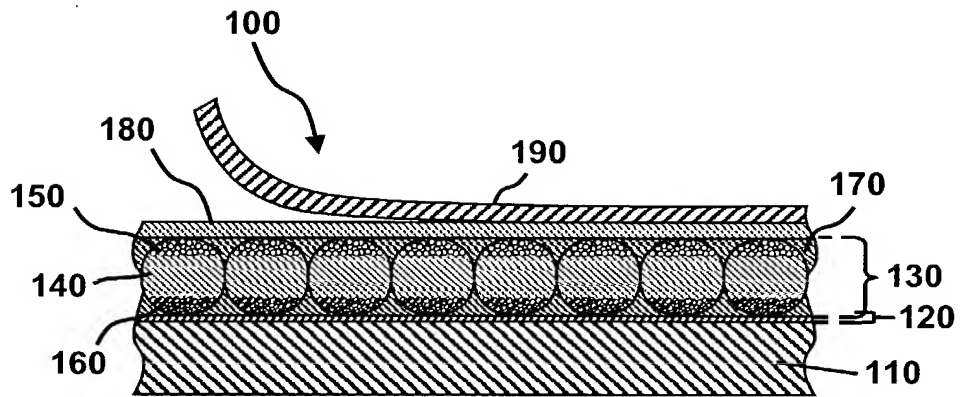


Fig. 1

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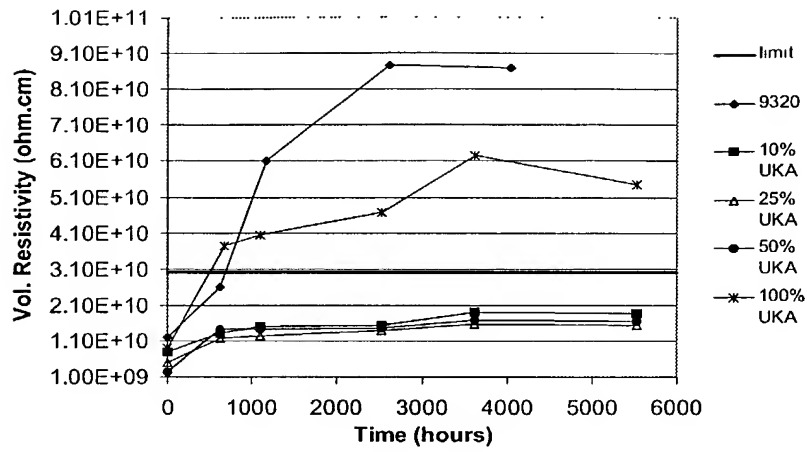


Fig. 2

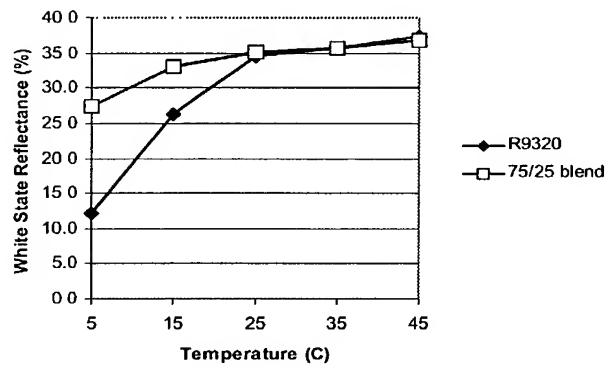


Fig. 11

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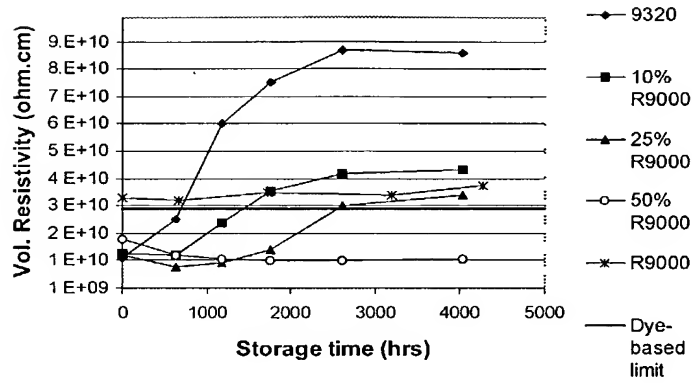


Fig. 3

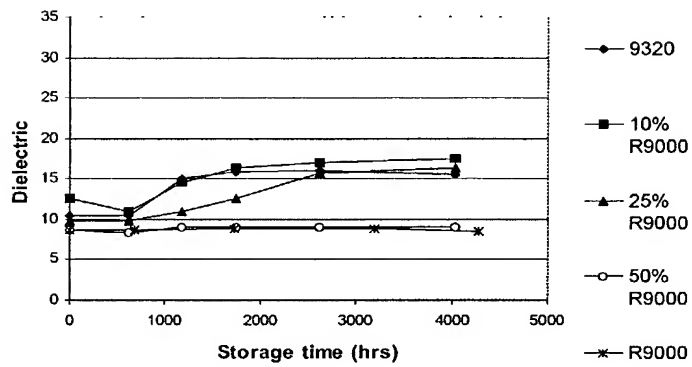


Fig. 4

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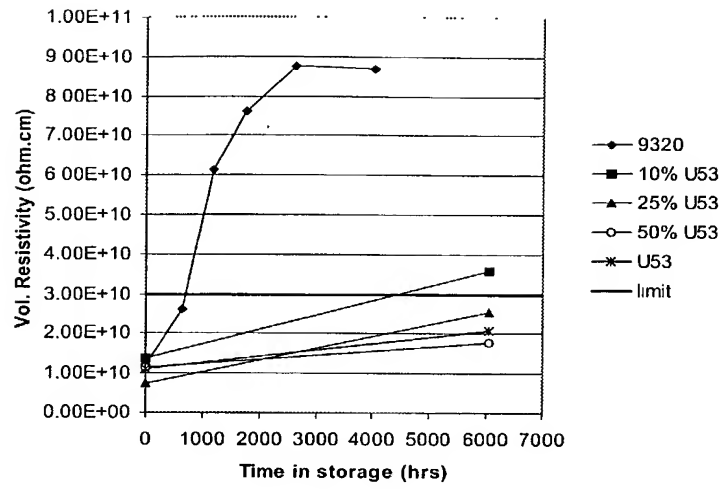


Fig. 5

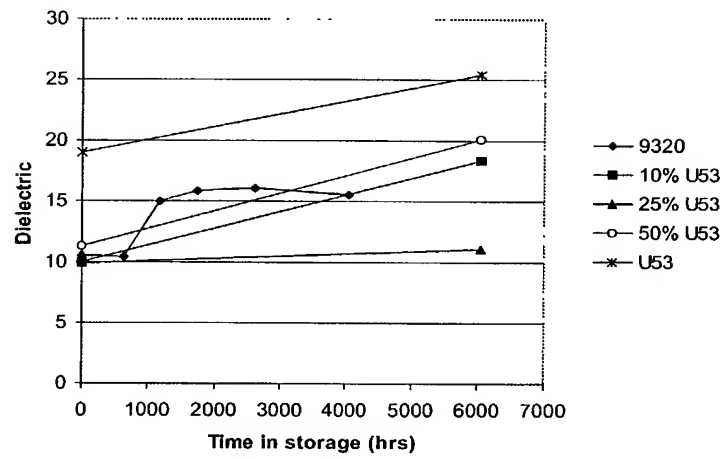


Fig. 6

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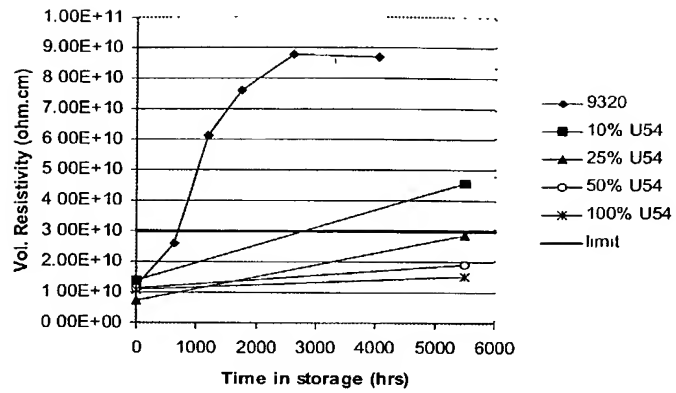


Fig. 7

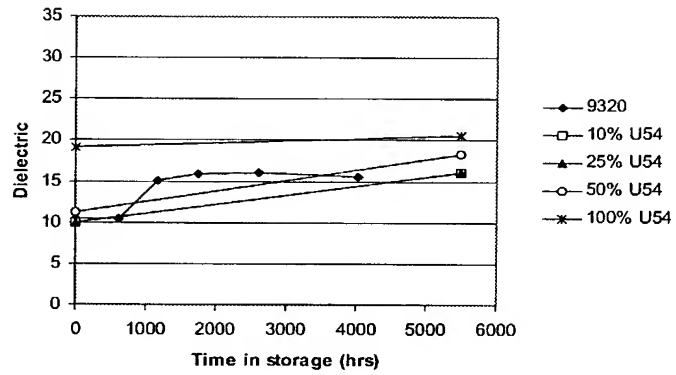


Fig. 8

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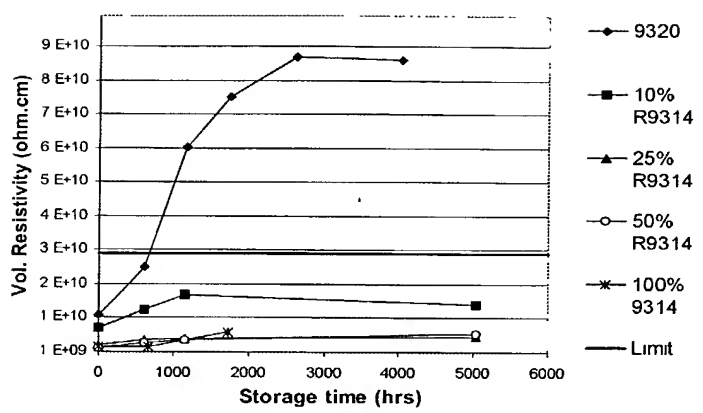


Fig. 9

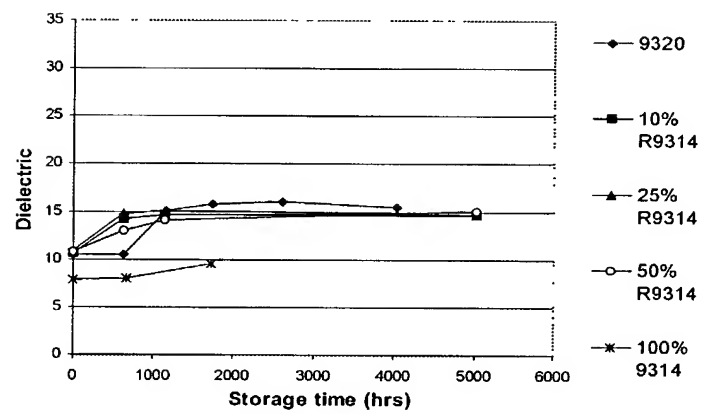


Fig. 10

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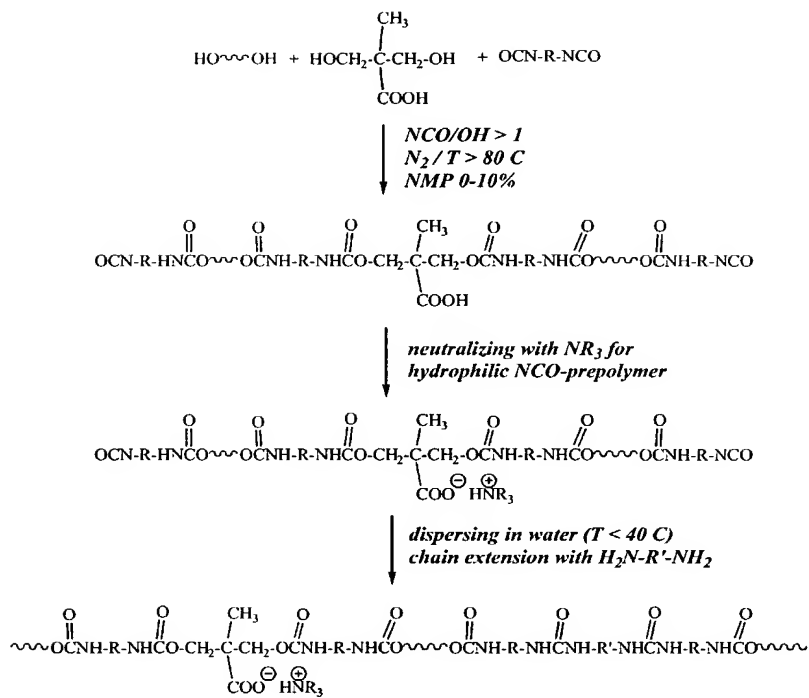


Fig. 12

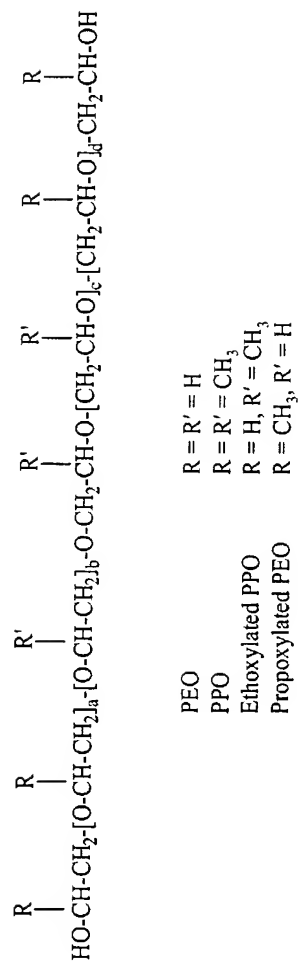


Fig. 13

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| <i>Materials</i> | <i>Wt (g)</i> | <i>Wt%</i> | <i>MW</i> | <i>Mole</i> | <i>Mole%</i> |
|---------------------|---------------|------------|-----------|-------------|--------------|
| PPO2000 | 50.00 | 0.653 | 2000.00 | 0.025 | 0.152 |
| DMPA | 3.35 | 0.044 | 134.13 | 0.025 | 0.152 |
| SnB2L2 | 0.04 | | 631.56 | | |
| NMP | 10.00 | | | | |
| H12MDI | 18.36 | 0.240 | 262.35 | 0.070 | 0.424 |
| TEA | 2.53 | 0.033 | 101.19 | 0.025 | 0.152 |
| H2O | 105.00 | | | | |
| HMDA | 2.32 | 0.030 | 116.21 | 0.020 | 0.121 |
| H2O in 50% HDA soln | 2.32 | | | | |

Theoretical polymer wt 76.57 g
Dispersion weight 193.94 g
Solids (%) 39.5%
NMP (%) 5.2%

Fig 14

| <i>Materials</i> | <i>Wt (g)</i> | <i>Wt%</i> | <i>MW</i> | <i>Mole</i> | <i>Mole%</i> |
|------------------|---------------|------------|-----------|-------------|--------------|
| PPO2000 | 50.00 | 0.673 | 2000.00 | 0.025 | 0.172 |
| DMPA | 3.35 | 0.045 | 134.13 | 0.025 | 0.172 |
| SnB2L2 | 0.04 | | 631.56 | | |
| NMP | 10.00 | | | | |
| H12MDI | 18.36 | 0.247 | 262.35 | 0.070 | 0.483 |
| TEA | 2.53 | 0.034 | 101.19 | 0.025 | 0.172 |
| H2O | 100.00 | | | | |

Polymer weight 74.25 g
Dispersion weight 184.29 g
Solids (%) 40.3%

Fig 15